

Date: Monday, 10/11/2008 10:44:00 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TAIL LIGHT FAIRING
<b>Job Number</b> : 43276	
<b>Estimate Number</b> : 12364	
<b>P.O. Number</b> :	<b>Part Number</b> : D3484041
<b>This Issue</b> : 10/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3484 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 34462	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 21/11/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>SPD 08.11.10</u>	
<b>Comment</b> : Est Rev:A New Issue 06-04-11 JLM Est Rev:B 08-01-24 change rivet to CR1122-3-025 DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D34841	Base, LH
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 BASE, LH  
 Batch: B30770

FF 08/11/10

①

2.0	D34843	Face, LH
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 FACE, LH  
 Batch: B30772

FF 08/11/10

①

3.0	D34845	Cone, LH
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 CONE, LH  
 Batch: B36402

FF 08/11/10

①

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig  
 A/R AL ROD Batch: M109213

2-Buff &amp; Smooth Welds to mating surfaces

Cpl 08.11.19

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/11/2008 10:44:00 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 43276

Part Number: D3484041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/19

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/20

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

08-11-20

X14H

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/11/21

9.0

CR1122 3 025

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch: 1106878

SB

08/11/21

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

ANCHOR NUT

Batch: 1103693

SB

08/11/21

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

FT 08/11/21

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/11/2008 10:44:00 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 43276

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



M 109152



(IX)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00  
320°F  
10:30

M-L 08/11/21

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Soslu/21 (X) LHC

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-141 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

PPR. 43265

JS 08/11/21 (X) U

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslu/21 (X) LHC

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/21 JS

Job Completion



MF 08-11-21

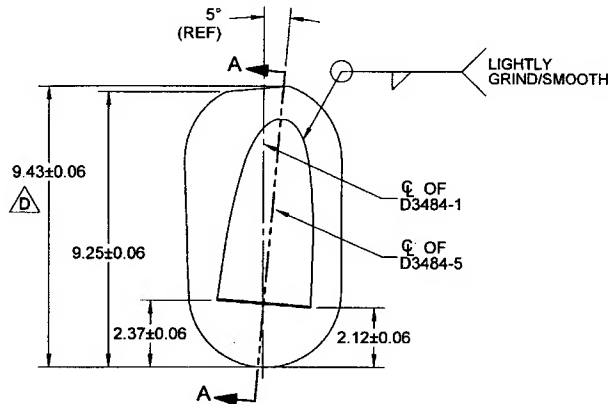
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

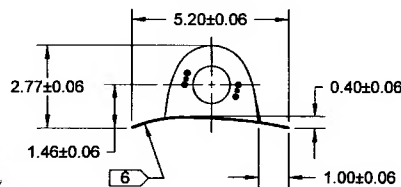
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

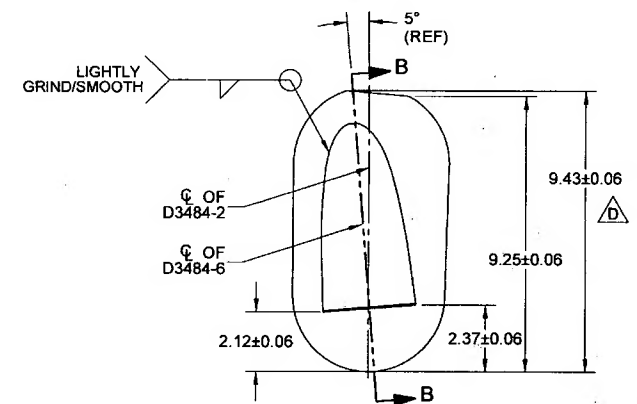


QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT

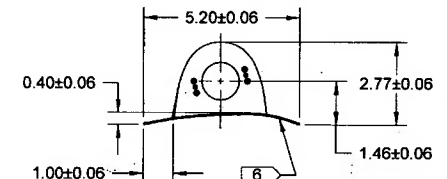


SECTION A-A

D3484-041 TAIL LIGHT FAIRING

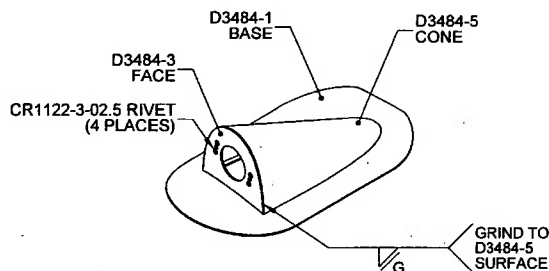


INSTALL MS21069-04  
ANCHOR NUT  
(2 PLACES)

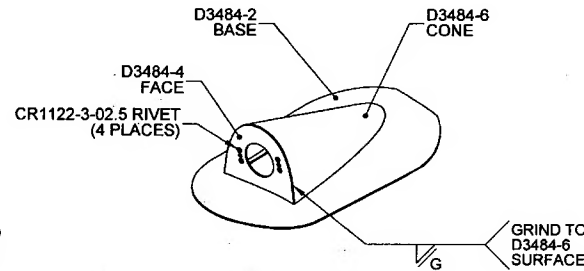


SECTION B-B

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL: "TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs

RELEASED

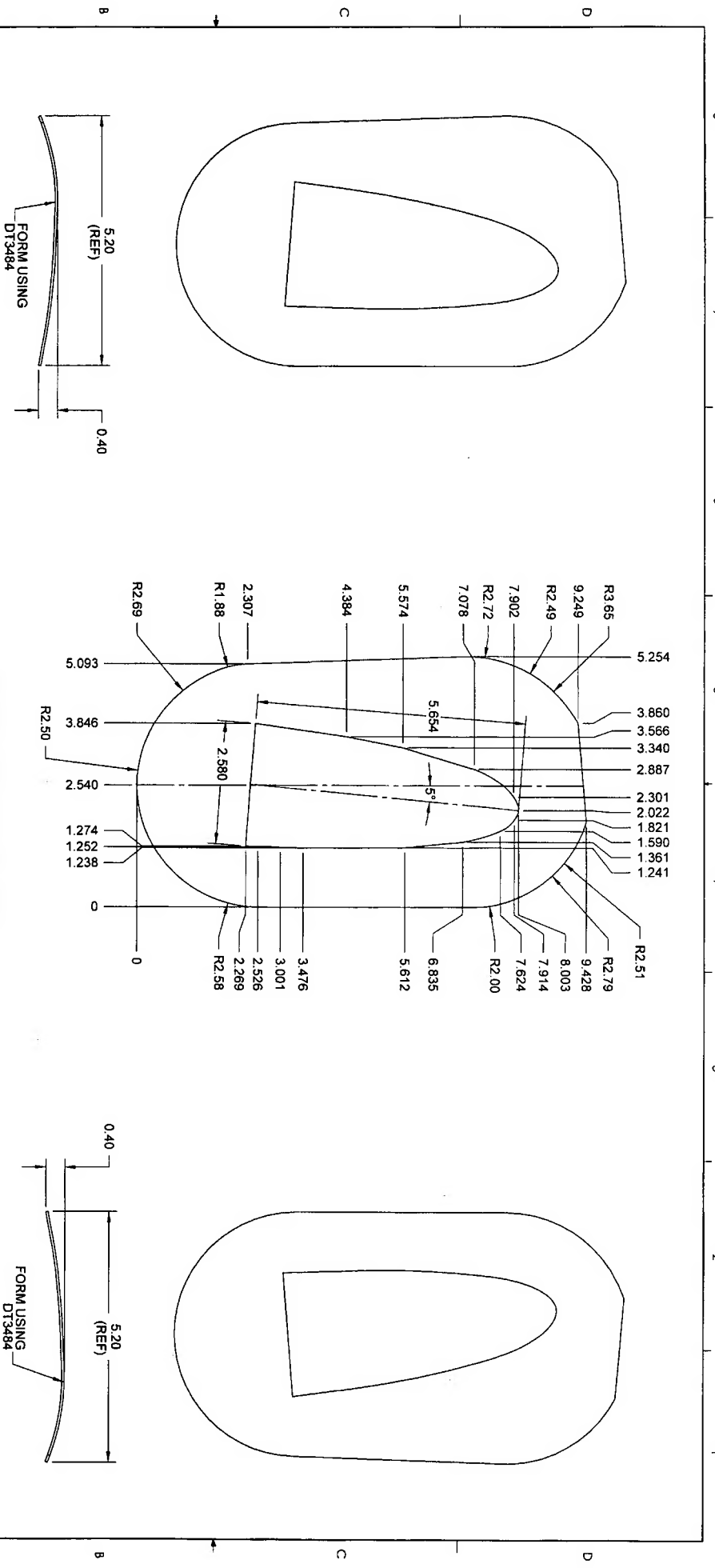
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.03		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3484  
SHEET 1 OF 4  
TITLE TAIL LIGHT FAIRING  
SCALE 1:4

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NO. 4730274



**D3484-1 BASE**  
(MAKE FROM D3484-1F)

**D3484-1F BASE FLAT PATTERN**

**D3484-2 BASE**  
(MAKE FROM D3484-1F)

**RELEASED**  
11-06-01-17-14

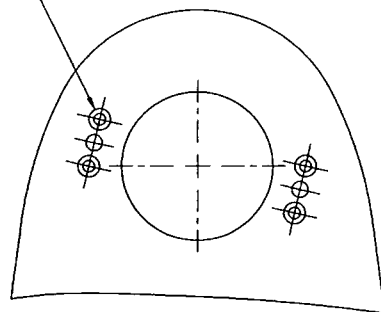
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.16 lbs

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TITLE	D3484	REV. E
TAIL LIGHT FAIRING		SHEET 2 OF 4
SCALE		1:2

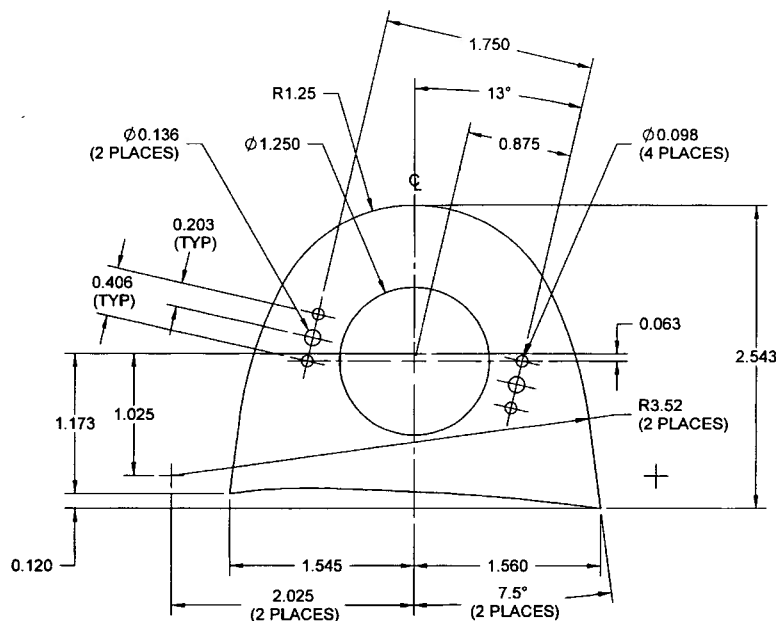
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C'SINK  
Ø0.181 X 100°  
(4 PLACES)

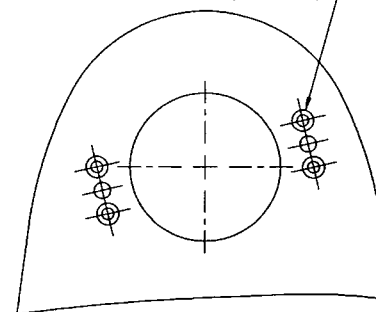


**D3484-3 FACE**  
(MAKE FROM D3484-3F)



**D3484-3F FLAT PATTERN TAIL LIGHT FAIRING**

C'SINK  
Ø0.181 X 100°  
(4 PLACES)



**D3484-4 FACE**  
(MAKE FROM D3484-3F)

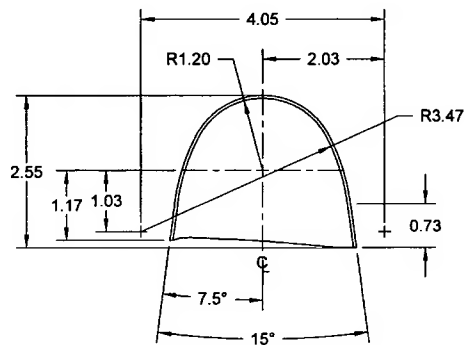
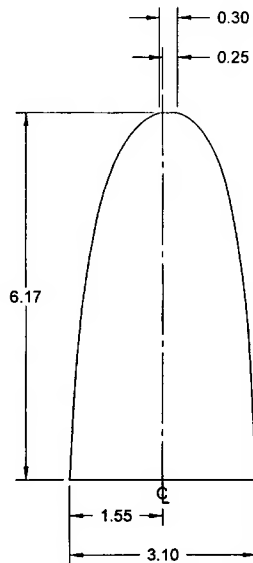
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

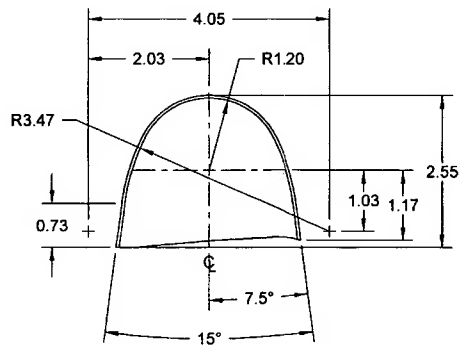
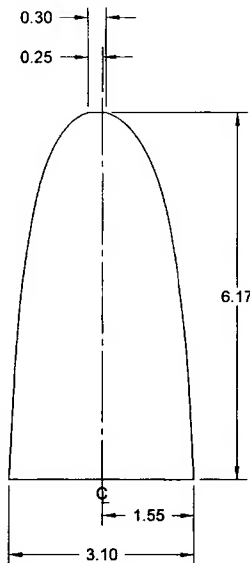
NO  
1792214  
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08-01-17

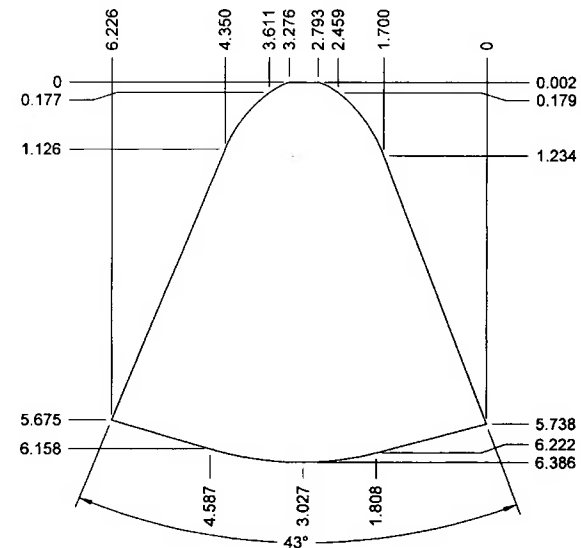
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DRAWN		DRAWING NO.	REV. E
CHECKED		D3484	SHEET 3 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		TAIL LIGHT FAIRING	1:1
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DATE	08.01.03		



**D3484-5 CONE**  
(MAKE FROM D3484-5F)



**D3484-6 CONE**  
(MAKE FROM D3484-5F)



**D3484-5F CONE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

RELEASED  
11/01/17

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MFG. APPR.		D3484	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>TAIL LIGHT FAIRING</b>	
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